



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2885**Job Sheet 199233****Part No:** D2885**Job Qty:** 10 pcs**Part Name:** Saddle Spacer**Part Weight:** 0 lbs**Status:** New**Priority:** Medium**Job Created:** 8/15/19**Job Tracking No:****Due Date:** 8/30/19**Created By:** Marie Lajeunesse**Type:** Stock**Description:**

Note: DWG REV B IPP A 99.10.12 New Issue EC IPP Rev:B Now 6060-T6 06-06-23 JLM IPP Rev:C waterjet 06-07-23 ec

Ship Via:**Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs		8/30/19	0.17	0.15	Waterjet - Flow		08/19/20
110	QC 2	10 pcs		8/30/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		08/19/20
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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				Handfinish - 1 - 21 - B4B	
				Handfinish - 1 - 22 - B4B	
140	QC 7	10 pcs	8/30/19	0.00 0.00	QC 7 - 10
					QC 7 - 13
					QC 7 - 14
					QC 7 - 15
					QC 7 - 17
					QC 7 - 18
					QC 7 - 19
					QC 7 - 2
					QC 7 - 28
					QC 7 - 3
					QC 7 - 30
					QC 7 - 34
					QC 7 - 36
					QC 7 - 37
					QC 7 - 41
					QC 7 - 47
					QC 7 - 48
					QC 7 - 51
					QC 7 - 58
					QC 7 - 59
					QC 7 - 60
					QC 7 - 9
					QC 7 - 68
					QC 7 - 50
					QC 7 - 67
					QC 7 - 40
					QC 7 - 24
					QC 7 - 43
					QC 7 - 61
					QC 7 - 81
150	Packaging 3-1 - Stock - B4B	10 pcs	8/30/19	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B

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				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
160	QC 21 - SA	10 pcs	8/30/19	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53
					Broussard

Part Op **100** - 1-Cut as per Dwg D2885 Dwg Rev: B Prog Rev: B 2-Deburr if necessary
 Descriptions: **110** - QC2- Inspect parts off machine FAI/FAIB
120 - QC8- Inspect parts - second check
130 - Chemical Conversion Coat per QSI005 4.1
140 - QC7-Inspect Chemical Conversion Coat
150 - Identify as per dwg & Stock Location: _____
160 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.080	6061-T6 .080 Sheet	.2570 sf (.0257 ea)	100-Waterjet - Flow - 1	5167936

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M6061T6S.080	0	228	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Saddle Spacer	0.430Inches $\pm$ 0.030	0.460 0.400		
			.424		
2	Saddle Spacer	0.443Inches $\pm$ 0.010	0.453 0.433		
			.444		
3	Saddle Spacer	0.257Inches $\pm$ 0.006 - 0.001	0.263 0.256	Diameter	
			.260		
4	Saddle Spacer	0.300Inches $\pm$ 0.030	0.330 0.270	Radius	
			.300		
5	Saddle Spacer	0.679Inches $\pm$ 0.010	0.689 0.669		
			.676		
6	Saddle Spacer	0.400Inches $\pm$ 0.030	0.430 0.370	Radius	
			.400		
7	Saddle Spacer	0.250Inches $\pm$ 0.030 - 0.000	0.280 0.250		
			.256		
8	Saddle Spacer	0.672Inches $\pm$ 0.010	0.682 0.662		
			.671		
9	Saddle Spacer	0.521Inches $\pm$ 0.010	0.531 0.511		
			.524		
10	Saddle Spacer	1.340Inches $\pm$ 0.010	1.350 1.330		
			1.339		
11	Saddle Spacer	2.681Inches $\pm$ 0.010	2.691 2.671		
			2.686		
12	Saddle Spacer	3.710Inches $\pm$ 0.030	3.740 3.680		
			3.705		
13	Saddle Spacer	0.380Inches $\pm$ 0.030	0.410 0.350	Radius	
			.380		
14	Saddle Spacer	0.528Inches $\pm$ 0.010	0.538 0.518		
			.529		
15	Saddle Spacer	0.080Degrees $\pm$ 0.500	0.580 (0.420)	Angle	
			.080		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S206988



Part: D2885

Job No: 199233

Serial No/Batch: S206988

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-6200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/20/19